

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024053**Date Inspected:** 07-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 1

This QA inspector observed ZPMC in process of heat straightening on Bike Path Handrail Assembly. ZPMC CWI Huang Min was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10267

BKR-NS-3

Bay 5

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening on traveler rail assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20913

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Weld- 3026TR1-001-019
WPS-345-FCAW-2G(2F)-ESAB-Repair
Welder- 066439
2G/FCAW/CJP

Heat Straightening
HSR1 (B) 10284
3023TR1-003

Bay 7

This QA inspector observed ZPMC in process of welding on cantilever box beam assembly. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder operator and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BKSA015-001-015, 016
WPS-B-T-2221-TC-U4a-S-2
Welder- 044771
1G/SAW/CJP

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening on traveler rail assemblies. ZPMC CWI Chen Shi Gang was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

Weld- 3003TR2-001-018, 020, 024, 029, 030
WPS-B-T-2231-ESAB
Welder- 059421

Weld- 3003TR2-001-025
WPS-B-T-2231-ESAB
Welder- 203805

Heat Straightening
HSR1 (B) 10284
3013TR2-002

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents

Summary of Conversations:

Summary of Conversations: "As noted within the contents of this report."

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
